



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D2587**

**Job Sheet 212735**



DAS  
21  
9-89

Part No: D2587

Job Qty: ~~12~~ pcs

Part Name: Door Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/2/20

Job Tracking No:

Due Date: 9/14/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A1 IPP D 04.05.31 Step 2 changed KJ/JLM IPP

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation           | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|---------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                     |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 100   | Waterjet - Flow - 1 | 12 pcs |            | 9/12/20  | 0.17      | 0.25    | Waterjet - Flow       |           | on 20/09/08 |
| 120   | QC 8                | 12 pcs |            | 9/12/20  | 0.00      | 0.00    | QC 8 - 12             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 14             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 17             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 20             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 25             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 3              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 32             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 33             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 35             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 39             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 4              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 44             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 45             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 49             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 58             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 8              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 9              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 68             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 67             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 1 (A)          |           |             |
|       |                     |        |            |          |           |         | QC 8 - 47             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 40             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 52             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 23             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 57             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 76             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 61             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 66             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 73             |           |             |

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|                                   |        |         |           |                                        |  |
|-----------------------------------|--------|---------|-----------|----------------------------------------|--|
|                                   |        |         |           | QC 8 - 82                              |  |
| 130 Handfinish - 1-1 Chemical-B4B | 12 pcs | 9/14/20 | 0.00 0.12 | Handfinish - 1 - 1 - B4B               |  |
|                                   |        |         |           | Handfinish - 1 - 2 - B4B               |  |
|                                   |        |         |           | Handfinish - 1 - 3 - B4B               |  |
|                                   |        |         |           | Handfinish - 1 - 4 - B4B               |  |
|                                   |        |         |           | Handfinish - 1 - 5 - B4B               |  |
|                                   |        |         |           | Handfinish - 1 - 6 - B4B               |  |
|                                   |        |         |           | Handfinish - 1 - 7 - B4B               |  |
|                                   |        |         |           | Handfinish - 1 - 8 - B4B               |  |
|                                   |        |         |           | Handfinish - 1 - 9 - B4B               |  |
|                                   |        |         |           | Handfinish - 1 - 10 - B4B              |  |
|                                   |        |         |           | Handfinish - 1 - 11 - B4B              |  |
|                                   |        |         |           | Handfinish - 1 - 12 - B4B              |  |
|                                   |        |         |           | Handfinish - 1 - 13 - B4B              |  |
|                                   |        |         |           | Handfinish - 1 - 14 - B4B              |  |
|                                   |        |         |           | Handfinish - 1 - 15 - B4B              |  |
|                                   |        |         |           | Handfinish - 1 - 16 - B4B              |  |
|                                   |        |         |           | Handfinish - 1 - 17 - B4B              |  |
|                                   |        |         |           | Handfinish - 1 - 18 - B4B              |  |
|                                   |        |         |           | Handfinish - 1 - 19 - B4B              |  |
|                                   |        |         |           | Handfinish - 1 - 20 - B4B              |  |
|                                   |        |         |           | Handfinish - 1 - 21 - B4B              |  |
|                                   |        |         |           | Handfinish - 1 - 22 - B4B              |  |
| 140 QC 3                          | 12 pcs | 9/14/20 | 0.00 0.00 | QC 3 - 10                              |  |
|                                   |        |         |           | QC 3 - 13                              |  |
|                                   |        |         |           | QC 3 - 15                              |  |
|                                   |        |         |           | QC 3 - 17                              |  |
|                                   |        |         |           | QC 3 - 18                              |  |
|                                   |        |         |           | QC 3 - 2                               |  |
|                                   |        |         |           | QC 3 - 28                              |  |
|                                   |        |         |           | QC 3 - 3                               |  |
|                                   |        |         |           | QC 3 - 30                              |  |
|                                   |        |         |           | QC 3 - 34                              |  |
|                                   |        |         |           | QC 3 - 36                              |  |
|                                   |        |         |           | QC 3 - 41                              |  |
|                                   |        |         |           | QC 3 - 51                              |  |
|                                   |        |         |           | QC 3 - 58                              |  |
|                                   |        |         |           | QC 3 - 59                              |  |
|                                   |        |         |           | QC 3 - 68                              |  |
|                                   |        |         |           | QC 3 - 9                               |  |
|                                   |        |         |           | QC 3 - 40                              |  |
|                                   |        |         |           | QC 3 - 19                              |  |
|                                   |        |         |           | QC 3 - 43                              |  |
|                                   |        |         |           | QC 3 - 24                              |  |
|                                   |        |         |           | QC 3 - 61                              |  |
|                                   |        |         |           | QC 3 - 81                              |  |
|                                   |        |         |           | QC 3 - 82                              |  |
|                                   |        |         |           | QC 3 - 87                              |  |
|                                   |        |         |           | TW 2020/09/11                          |  |
|                                   |        |         |           | Plex 9/2/20 7:21 AM dart.lacelle.linda |  |



|                                 |           |         |           |                         |                    |
|---------------------------------|-----------|---------|-----------|-------------------------|--------------------|
| 150 Packaging 3-1 - Stock - B4B | 12<br>pcs | 9/14/20 | 0.00 0.00 | QC 3 - 47               |                    |
|                                 |           |         |           | Packaging 3 - 1 - B4B   |                    |
|                                 |           |         |           | Packaging 3 - 2 - B4B   |                    |
|                                 |           |         |           | Packaging 3 - 3 - B4B ✓ | SEP 14 2020 DAS 80 |
|                                 |           |         |           | Packaging 3 - 4 - B4B   | ST008 9-89         |
|                                 |           |         |           | Packaging 3 - 5 - B4B   |                    |
|                                 |           |         |           | Packaging 3 - 6 - B4B   |                    |
|                                 |           |         |           | Packaging 3 - 7 - B4B   |                    |
|                                 |           |         |           | Packaging 3 - 8 - B4B   |                    |
|                                 |           |         |           | Packaging 3 - 9 - B4B   |                    |
|                                 |           |         |           | Packaging 3 - 10 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 11 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 12 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 13 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 14 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 15 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 16 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 17 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 18 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 19 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 20 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 21 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 22 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 23 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 24 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 25 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 26 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 27 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 28 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 29 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 30 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 31 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 32 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 33 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 34 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 35 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 36 - B4B  |                    |
|                                 |           |         |           | Packaging 3 - 37 - B4B  | DAS 21             |
| 160 QC 21 - SA                  | 12<br>pcs | 9/14/20 | 0.00 0.00 | QC 21 - SA - 21         | 9-89 SEP 14 202    |
|                                 |           |         |           | QC 21 - SA - 70         |                    |
|                                 |           |         |           | QC 21 - SA - 9          |                    |
|                                 |           |         |           | QC 21 - SA - 77         |                    |
|                                 |           |         |           | QC 21 - SA - 28         |                    |

Part Op 100 - 1-Cut as per Dwg D2587  
 Descriptions: 120 - (QC8- Inspect parts - second check)  
 130 - (Chemical Conversion Coat per QSI005 4.1)  
 140 - (QC3- Inspect Part Finish)  
 150 - (Identify as per dwg & Stock Location: \_\_\_\_\_)  
 160 - (QC21- Final Inspection - Work Order Release)

#### Job BOM

| Part / Item  | Component Name     | Quantity           | Operation               | Container |
|--------------|--------------------|--------------------|-------------------------|-----------|
| M6061T6S.040 | 6061-T6 .040 Sheet | .1920 sf (.016 ea) | 100-Waterjet - Flow - 1 | S257536   |

#### Job Allocations

| Operation               | Component Part | Required | Inventory | Allocated |
|-------------------------|----------------|----------|-----------|-----------|
| 100-Waterjet - Flow - 1 | M6061T6S.040   | 0        | 89        | 0         |

| Part Specifications |             |                         |                |      |                  |
|---------------------|-------------|-------------------------|----------------|------|------------------|
| Spec No             | Description | Target/Tolerance        | Limits         | Type | Special Comments |
| 1                   | Door Slug   | 1.500inches $\pm$ 0.010 | 1.510<br>1.490 |      |                  |
| 2                   | Door Slug   | 0.040inches $\pm$ 0.010 | 0.050<br>0.030 |      |                  |

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**Container No: S298796**



**Part: D2587**

**Job No: 212735**

**Serial No/Batch: S298796**

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

**Dart Aerospace Ltd.**  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

**Date: 09/08/20**